

Split

Work Order ID 127657-2

127657

Page 1

December-17-14 1:42:21 PM

Item ID: D4775-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Strut Assembly
Start Date: 12/26/14 Start Qty: 5.00 *5* Cust Item ID:
Required Date: 12/26/14 Req'd Qty: 5.00 *5* Customer:
Reference:

Approvals: Process Plan: ML5 Date: 14-12-23 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4775	C
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110

Pick Kit
Large Fab

0.00

110

Packaging

Memo

0.00

Packaging

4 FF JAN 12 2015

120

0.00

120

Small Fab

Memo

0.00

Small Fab

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: 17130090

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

24 FF JAN 12 2015

Work Order ID 127657

December-17-14 1:42:21 PM

127657

Page 2

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 Item Name: Strut Assembly
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 Required Date: 12/26/14 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(2)			DAS 38 9-89 JAN 14 2015
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: ST514 Memo	0.00 0.00				2			DAS 80 8-89 JAN 14 2015
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MCS 1501-14 15-1-14

Picklist Print

December-17-14 1:42:20 PM

Page 1

Work Order ID: 127657

127657

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 12/26/14

Required Date: 12/26/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
REV:B 13.08.26 PB1 DD VERF:JLM
13.09.26 AS PER REV.B DD VERF:JLM
AS PER REV.C DD VERF:JLM
IPP
IPP REV:C
IPP REV:D 14.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 *D4775-1* Strut Tube		Manufactured	No			110	Each	4.0000	1	5			
									**		FF	JAN 12 2015	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST514			4					
					126819			4		4			
D4777-1 *D4777-1* Rod End Bearing		Manufactured	No			110	Each	0.0000	1	5			
									**		4 FF	JAN 12 2015	
D4776-1 *D4776-1* Basket Strut Clevis		Manufactured	No			110	Each	4.0000	1	5			
									**		FF	JAN 12 2015	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST126			4					
					121785			1		1			
					122550			3		3			
D4776-5 *D4776-5* Spacer		Manufactured	No			110	Each	0.0000	4	20			
									**		16 FF	JAN 12 2015	
					127743								

145 30 6M

145 30 6M

145 30 6M

145 30 6M

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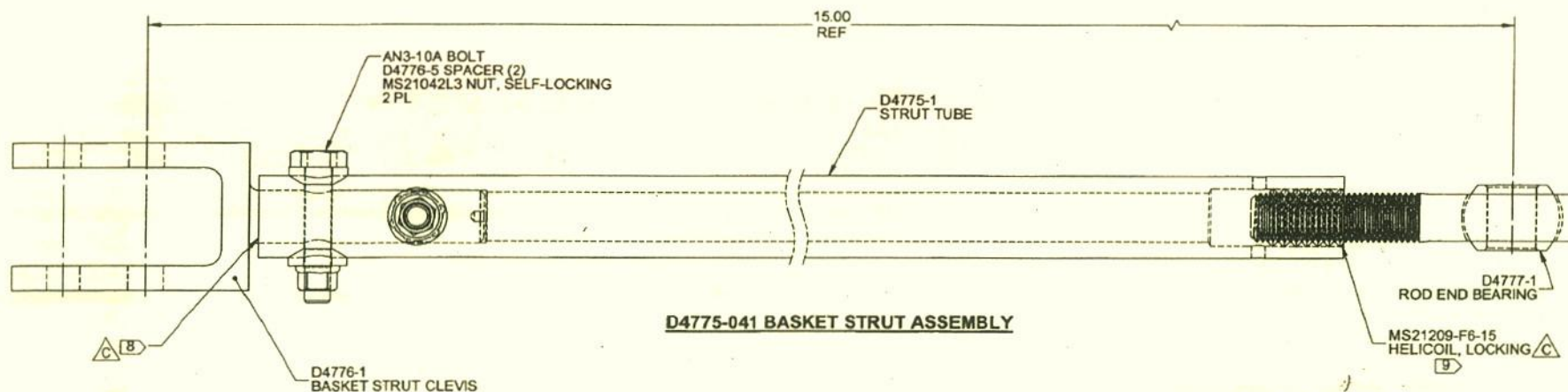
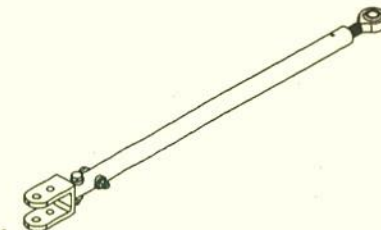
145 30 6M

145 30 6M

145 30 6M

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING

SHOOT COPY
RETURN TO
FACILITY
UNCONTROLLED COPY
SUBJECT TO REVISION
WITHDRAWN
NO 127657 MLC
14-12-23

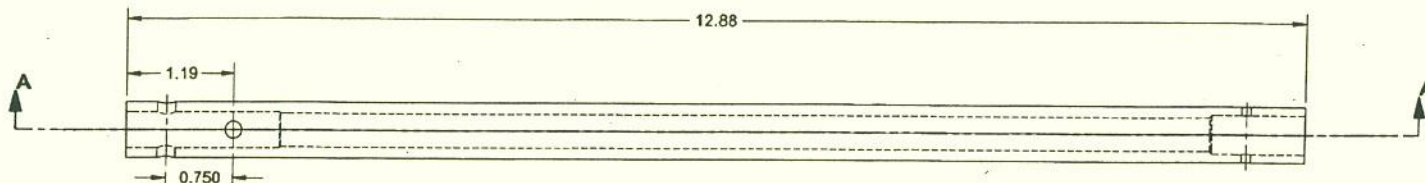


D4775-041 BASKET STRUT ASSEMBLY

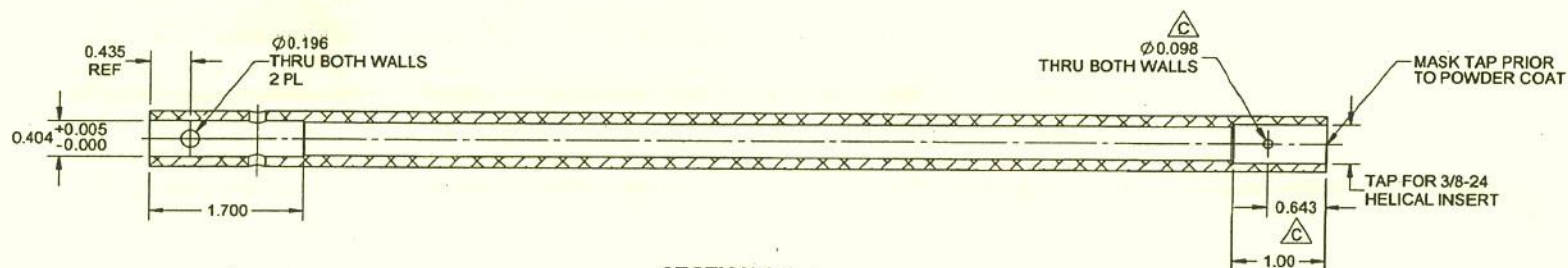
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 0.45 lbs
 - 8) APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTLING.
 - 9) ENSURE HELICOIL DOES NOT BLOCK HOLE

RELEASED
2014-01-07

C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK. ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C6-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2).	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4775 BASKET STRUT ASSEMBLY COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.		REV. C SHEET 1 OF 2 SCALE NTS DATE 13.11.01	



D4775-1 STRUT TUBE



SECTION A-A

NOTES:

- 1) MATERIAL: 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, $\phi 0.625 \times 0.125$ WALL
PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
OR AMS 4080 OR AMS 4082 OR AMS 4083
OR ASTM B210 OR ASTM B241
REF DART SPEC M6061T6T0.625W0.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

RELEASED
2014-01-08
W

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

